

**Work Order ID 113859**

February-24-14 10:05:16 AM

**\*113859\***

Page 1

Item ID: D3849-1

Revision ID:

Item Name: Plate

Start Date: 2/21/14

Start Qty: 8.00

**\*8\***

Required Date: 2/24/14

Req'd Qty: 8.00

**\*8\***

Reference:

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Run Start

**\*NR1\***

Stop

**\*NR2\***

Approvals:

Process Plan:

MLSDate: 14-02-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3849

D

100

0.00

**\*100\***

Waterjet

FLOW CNC Waterjet

304.050

Memo

1-Cut as per Dwg D3849

Dwg Rev: PProg Rev: D

2-Deburr if necessary

0.00

80Jan 14-03-26

110

0.00

**\*110\***

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

80Jan 14-03-26

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 113859

February-24-14 10:05:16 AM

**\*113859\***

Page 2

Item ID: D3849-1

Revision ID:

Item Name: Plate

Start Date: 2/21/14

Start Qty: 8.00

**\*8\***

Required Date: 2/24/14

Req'd Qty: 8.00

**\*8\***

Reference:

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

**\*NR1\***

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

DAS

27

9-89

0.00

14/3/26

8

**\*120\***

QC

Memo

Quality Control

130

Memo

0.00

0.00

8x

14/03/31

**\*130\***

Brake NC

Brake NC

Form as per dwg using DT8179 & DT8155

210

QC5- Inspect part completeness to step on W/O

0.00

DAS

27

9-89

0.00

14/4/11

8

**\*210\***

QC

Memo

Quality Control

DAS  
36  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

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**Work Order ID 113859**

February-24-14 10:05:16 AM

**\*113859\***

Page 3

Item ID: D3849-1

Revision ID:

Item Name: Plate

Start Date: 2/21/14

Start Qty: 8.00

**\*8\***

Required Date: 2/24/14

Req'd Qty: 8.00

**\*8\***

Reference:

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

Identify as per dwg & Stock Location: WAD02

0.00

**\*220\***

Packaging

Memo

0.00

Packaging

230

QC21- Final Inspection - Work Order Release

0.00

**\*230\***

QC

Memo

0.00

Quality Control

8 14-04-09 MALML 140411ME  
14-4-10

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Doc/Data									
Equip/Tooling									
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### FAULT CATEGORY

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# Picklist Print

February-24-14 10:05:15 AM

Page 1

Work Order ID: 113859

**\*113859\***

Parent Item: D3849-1

**\*D3849-1\***

Parent Item Name: Plate

Start Date: 2/21/14

Required Date: 2/24/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 12-08-23 JLM VERIFIED BY:DD IPP  
Rev:B 12.09.11 AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

100

sf

447.7500

3.585

~~30.18947~~

**\*M304S18GA\***

**\*\***

31

Jm14-23-26

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT019

434.75

117188

3

117766

5

120604

5

122325

3

123155

3

124572

38

M126647

39.75

M128254

338

MAT020

13

124029

2

M126098

11

128254

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Offset/Setup									
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Supplier									
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	113859
<b>Description:</b> Wearplate		<b>Part Number:</b>	D3849-1
<b>Inspection Dwg:</b> D3849	<b>Rev:</b> D	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+0.006/-0.001	0.377"	—		✓	Jkmos
0.125	+/-0.010	0.126"	—		✓	
0.88	+/-0.030	0.883"	—		✓	
2.433	+/-0.010	2.437"	—		✓	
6.642	+/-0.010	6.642"	—		✓	
2.45	+/-0.030	2.459"	—		✓	
18.000	+/-0.010	18.000"	—		T	Jkmos
36.000	+/-0.010	36.000"	—		T	
51.313	+/-0.010	51.313"	—		T	
7.00	+/-0.030	7.00"	—		✓	
41.50	+/-0.030	41.50"	—		T	
7.72	+/-0.030	7.72"	—		✓	
54.26	+/-0.030	54.26"	—		T	
0.050	+/-0.010	0.049"	—		✓	

<b>Measured by:</b> Jm	<b>Audited by:</b> DAS 27	<b>Preliminary Approval:</b>
<b>Date:</b> 14-03-26	<b>Date:</b> 14/3/26	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	09.10.01	New Issue P/O D3849-041	KJ	
B	12.10.26	Dimensions updated per Dwg Rev D	KJ	

0.3 REF

R38.5

49.51

**D3849-1 PLATE**  
(MAKE FROM D3849-1F)

A6-10

0.050  
REF

7.72

Ø0.188 THRU  
2 PL

D2-10

R0.38  
TYPH  
B3-10

A4-6

2.433  
TYP6.642  
4 PLR0.06  
2 PL105°  
TYPR0.50  
TYP

54.26 REF

49.27

D

43.51

41.50

40.00

34.00

29.00

23.00

18.69

14.38

10.06

7.00

5.75

0

**D3849-1F FLAT PATTERN**

R0.06  
TYP0.13  
REF

**DETAIL I**

C2-6  
B2-9

**RELEASE**  
2012-09-04

## NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240  
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.30 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	DC	KENT, WA	
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	JS	<b>D3849</b>	SHEET 6 OF 10
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	<b>WEARPLATE ASSY</b>	NTS
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8

7

6

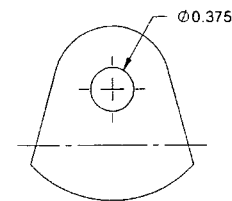
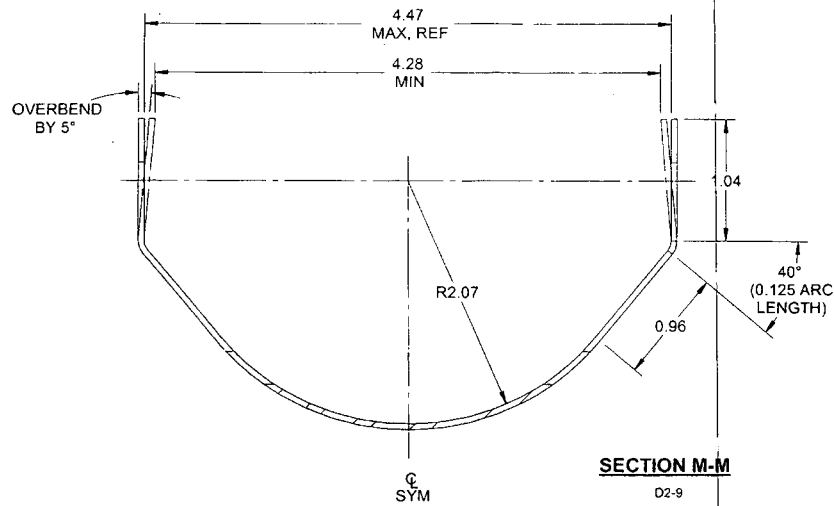
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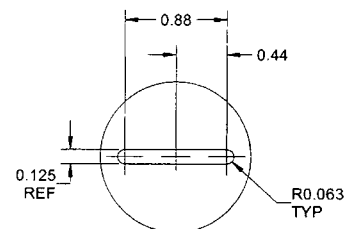
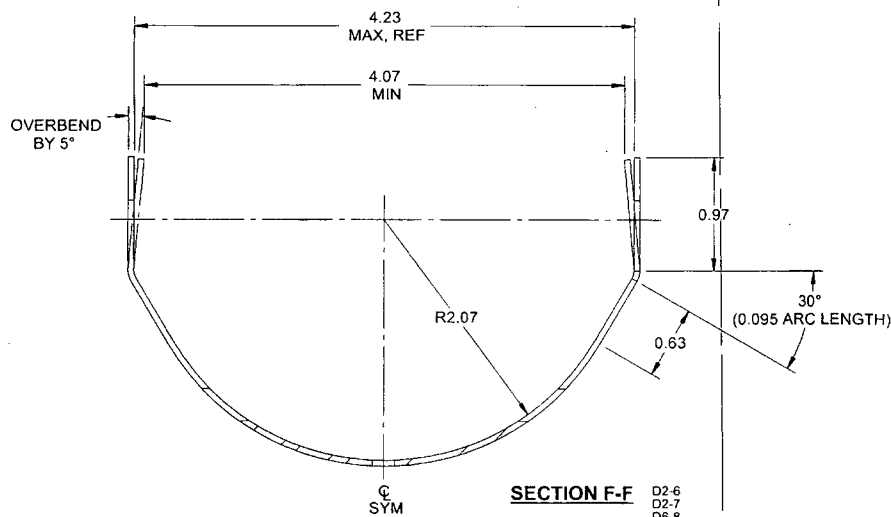
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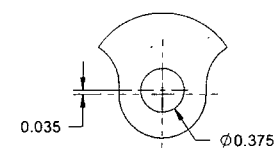


**DETAIL G**  
SLOT DETAIL TYP

C4-6  
C4-7  
C4-8  
C6-9



**DETAIL H**  
SLOT DETAIL TYP  
C3-6  
B3-9



**DETAIL L**  
DETAIL TYP  
B2-8

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